

Work Order ID 52268

September 22, 2009 8:41:02 AM



PRELIMINARY ISSUE

Page 1

Item ID: D212-725-1-247

Accept



Setup Start



Revision ID: G-PRELIM

Item Name: Cam

Stop



Start Date: 23/09/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 25/09/2009 Req'd Qty: 6.00

Customer:

Reference: *See 09.08.22*

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D212-725-1	G-PRELIM

100 0.00



Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks 3.250" long

0.00

mf 09/09/23

6

110 0.00



HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per folio FA843 and DWG

Folio rev: *AA*
Dwg Rev: *G-PRELIM*

Deburr as per Dwg

0.00

mf 09/09/23 / JK 09/09/24

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Start Date: 23/09/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 25/09/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	27/09/23 / 24 09/09/24						
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	09.09.24 (6)						
--160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	09/09/24 (X6)						

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Cust Item ID:

Required Date: 25/09/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/9/24 60 Sy

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CofC only 09/12/17

W 09-09-20

Picklist Print

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Page 1

Work Order ID: 52268

Parent Item: D212-725-1-247RevG-PRELIM

Parent Item Name: Cam

Comments:

Start Date: 23/09/2009

Required Date: 25/09/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.625X02.50 0		Purchased	No			100	f	7.8484	1.8947			



6061-T6 Bar .625 x 2.50



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

108961

7.8484

7.8484

POSITIVE RECALL

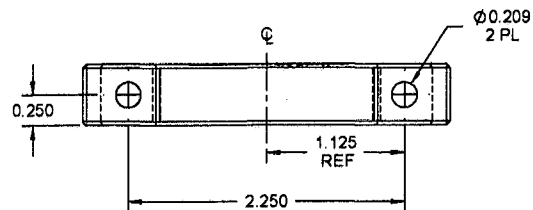
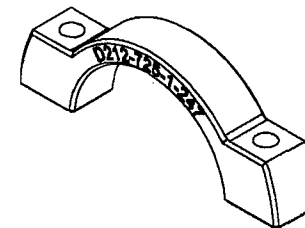
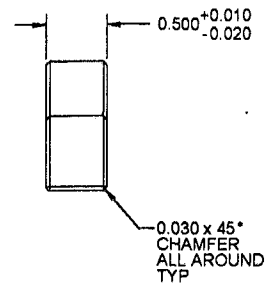
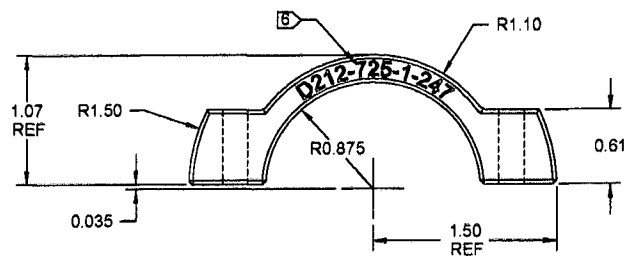
EFFECTIVE

RELEASED

DATE

9/12/06

RD 035 SEP



D212-725-1-247 RETAINER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4180)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.015 IN 0.125 HIGH LETTERS WITH A MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D212-725-1	SHEET 88 OF 88
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.09.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

L Lacelle

From: Harvey Siemens [hsiemens@dartaero.com]

Sent: December 16, 2009 1:03 PM

To: 'L Lacelle'

Linda

D212-725-1-245/-247 parts produced are acceptable.

Regards,

Harvey Siemens

Mechanical Designer

DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: hsiemens@dartaero.com

W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 5G9

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12/16/09